

SPLIT

Dart Aerospace Ltd.

Date: Friday, 04/04/2008 9:58:52 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 38408 -2		
Estimate Number	: 12784		
P.O. Number	:	Part Number	: D35649
This Issue	: 04/04/2008 S.O. No. :	Drawing Number	: D3564 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 04/04/2008 Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 37812	Material	:
Written By	:	Due Date	: 18/04/2008
Checked & Approved By	: <u>JLD 08.04.4</u>	Qty:	20 Um: Each
Comment	: Est Rev:A New Issue 07-03-08 ec : Est Rev:B As per Rev C 07-07-09 JLM : Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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33
33

Comment: Qty.: 1.1550 sf(s)/Unit Total: 23.1000 sf(s)
 M304S16GA Stainless steel sheet 0.063" thick
 Batch: _____

107513 x 6 = 7
 107676 x 22 = 26

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3564 ***** (D3564-1F)*****

Dwg Rev: D IB 8-4-10
 Prog Rev: D

2-Deburr if necessary IB 8-4-10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-4-10



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

50864110 28 28

5.0	BRAKE NC	NC BRAKE
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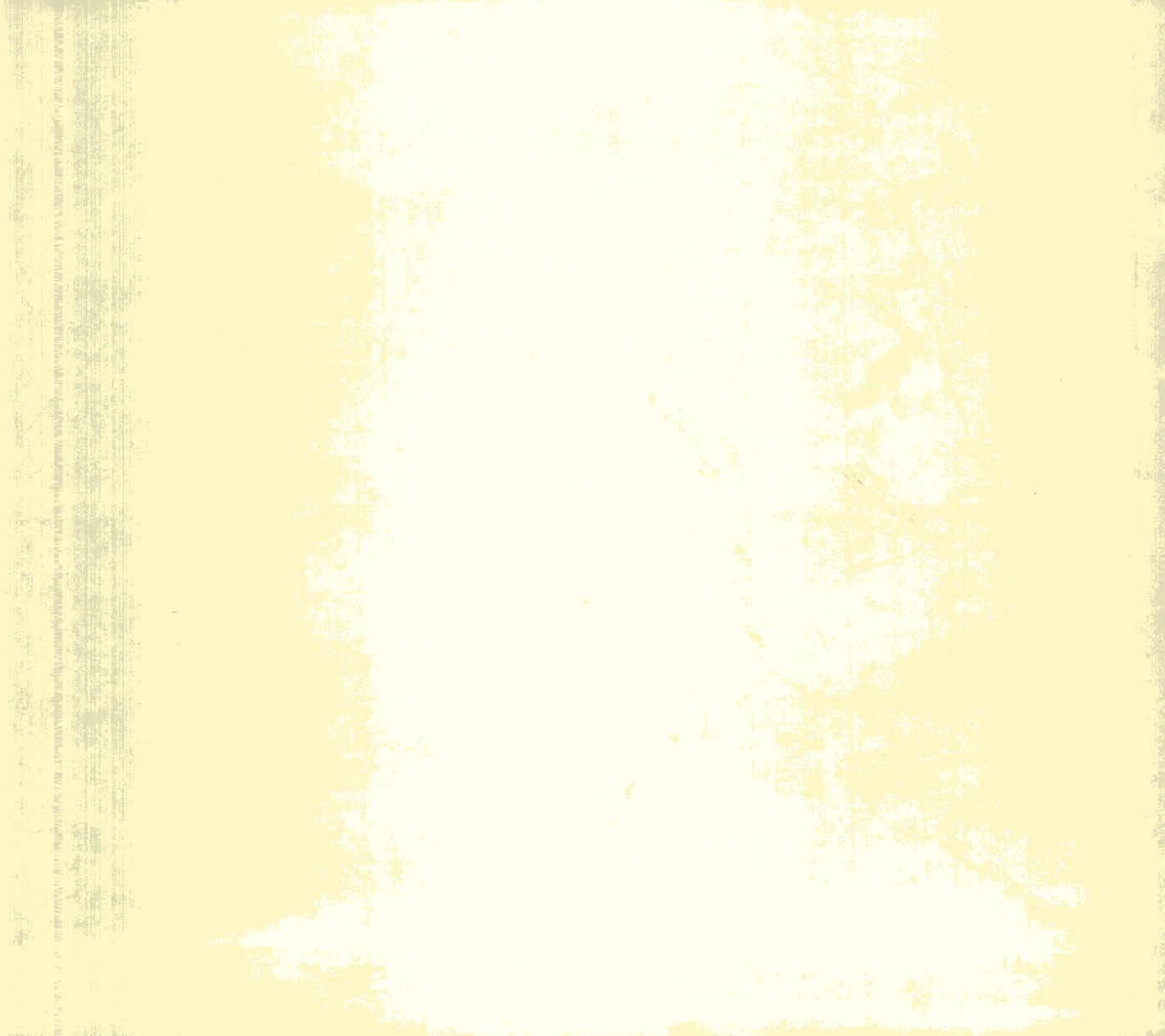


Comment: NC BRAKE

Deburr if necessary
 Form on Brake as per Dwg D3564 using Jigs DT 8179 and DT 8155

83 08/04/17

28



Date: Friday, 04/04/2008 9:58:52 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 38408

Part Number: D35649

Job Number:



Seq. #:

Machine Or Operation:

Description :

Form Joggle as per Dwg D3564 on brake using Jig DT 8157

SB 08/04/17 (28)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Ensure joggle as per dwg D3429

08/04/17 (128)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty	Description	Batch
A/R	2059B Hardcoat	M107051
Weld hardcoat as per Dwg D3564		

28x 19

08-04-21 SP

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/04/22 (10)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/22 (15)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 106442

BR 08-04-23

30 min.
23/04/2008
S.097 11.36
#1 317.1 F
#2 38408 F
#3 0.35649 F

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 08/04/23

(19X)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FP-18

M-L 08/04/23

1871
The following is a list of the names of the persons who have been
admitted to the membership of the Society since the last meeting.
The names are given in alphabetical order of their surnames.
The names of the persons who have been admitted to the membership
of the Society since the last meeting are given in alphabetical order
of their surnames.

Date: Friday, 04/04/2008 9:58:52 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 38408

Part Number: D35649

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-23

1871
The following is a list of the names of the persons who have been elected to the office of Justice of the Peace for the year 1871.

NAME	RESIDENCE
John A. Smith	St. Louis
James B. Jones	St. Louis
William C. Brown	St. Louis
Charles D. White	St. Louis
Edward F. Green	St. Louis
George H. Black	St. Louis
Franklin I. Gray	St. Louis
Henry J. Hall	St. Louis
Isaac K. King	St. Louis
John L. Lee	St. Louis
Samuel M. Miller	St. Louis
Thomas N. Moore	St. Louis
William O. Owen	St. Louis
James P. Parker	St. Louis
Robert Q. Quinn	St. Louis
Charles R. Reed	St. Louis
Edward S. Shaw	St. Louis
George T. Taylor	St. Louis
Franklin U. Underhill	St. Louis
Henry V. Vance	St. Louis
Isaac W. Walker	St. Louis
John X. Wright	St. Louis
Samuel Y. Young	St. Louis
Thomas Z. Zimmerman	St. Louis

DART AEROSPACE LTD		Work Order:	38408
Description: Wearshoe		Part Number:	D3564-9
Inspection Dwg: D3564	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

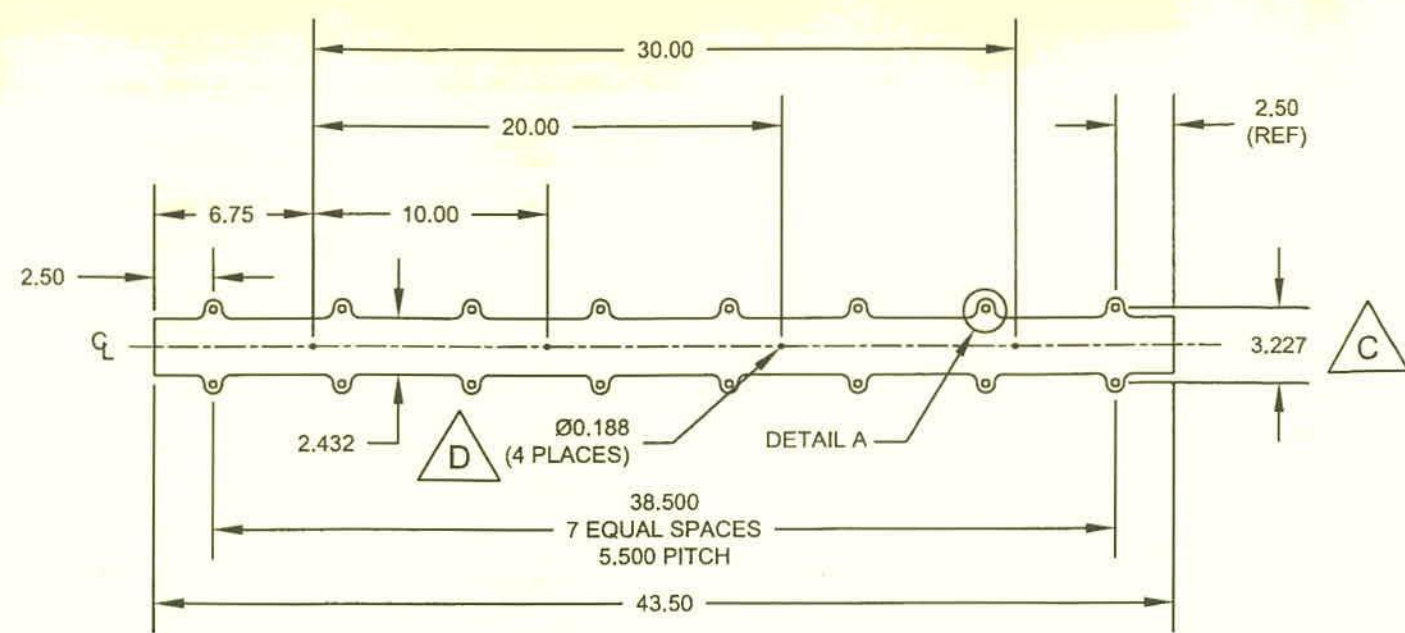
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.229	*			
2.432	+/-0.010	2.434	*			
2.50	+/-0.030	2.51	*			
6.000	+/-0.010	6.000	*			
12.104	+/-0.010	12.104	*			
18.000	+/-0.010	18.000	*			
18.000	+/-0.010	18.000	*			
18.00	+/-0.030	18.00	*			
9.00	+/-0.030	9.00	*			
11.50	+/-0.030	11.50	*			
0.300 x 0.300	+/-0.010	304x304	*			
Ø0.188	+0.005/-0.001	.191	*			
R0.375	+/-0.010	.375	*			
0.063	+/-0.010	.062	*			

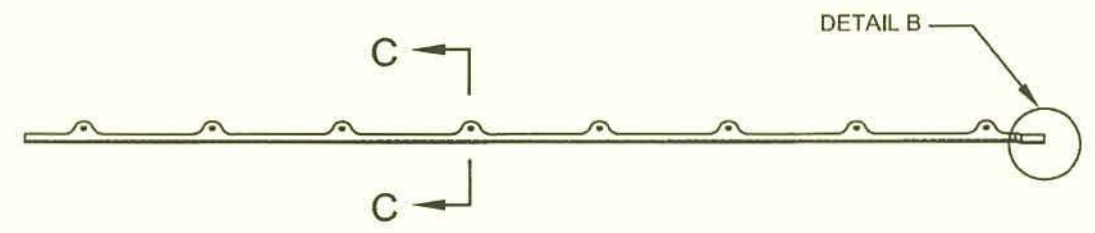
Measured by: JB	Audited by: [Signature]	Prototype Approval:	N/A
Date: JB 8-4-10	Date: 08/04/10	Date:	N/A

Rev	Date	Change	Revised by:	Approved
A	08.01.16	New Issue	KJ/EC/DD [Signature]	[Signature]

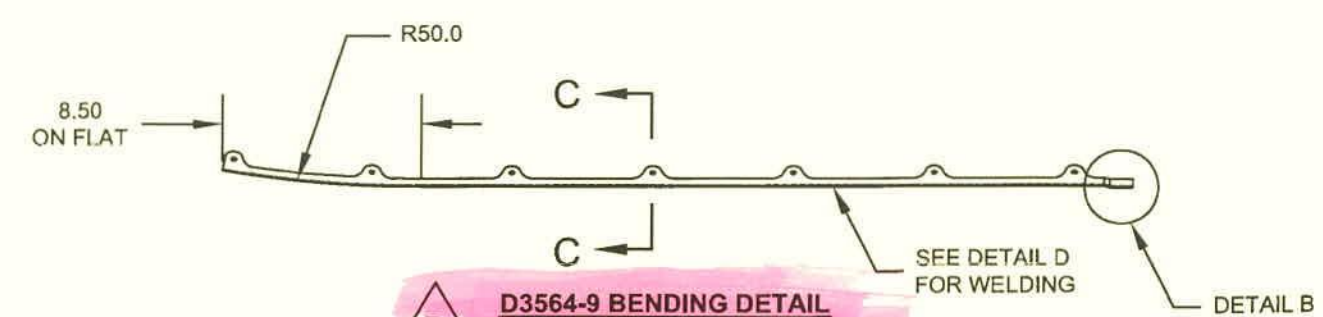
8 7 6 5 4 3 2 1



D3564-5F FLAT PATTERN

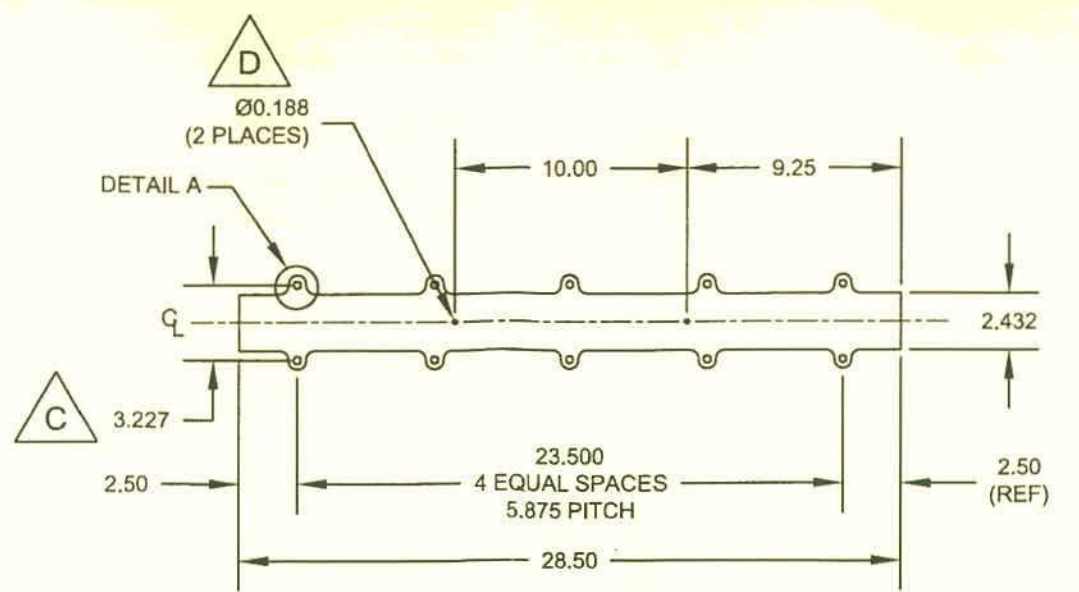


D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)

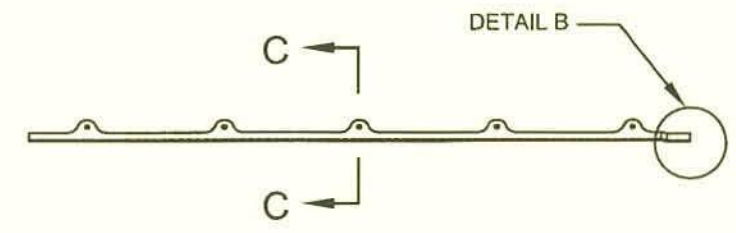


D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)

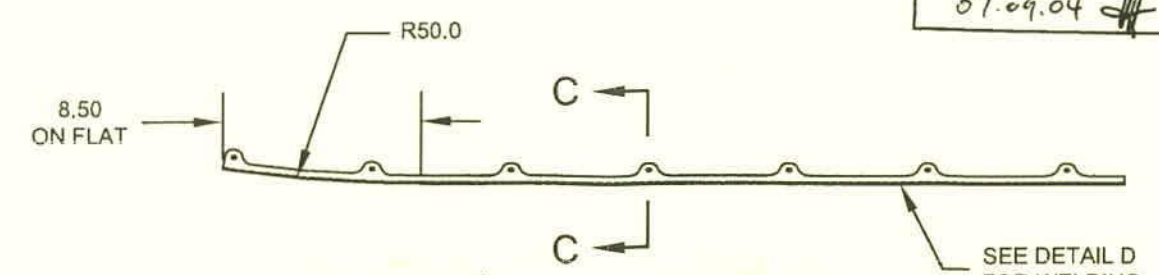
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D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED
07.09.04

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

8

7

6

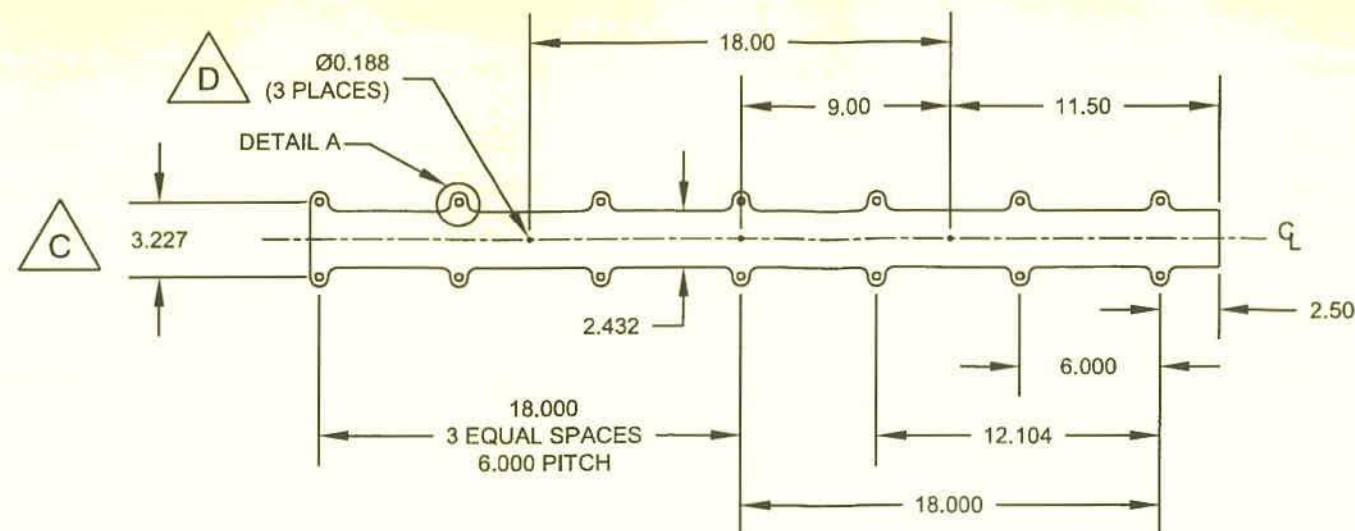
5

4

3

2

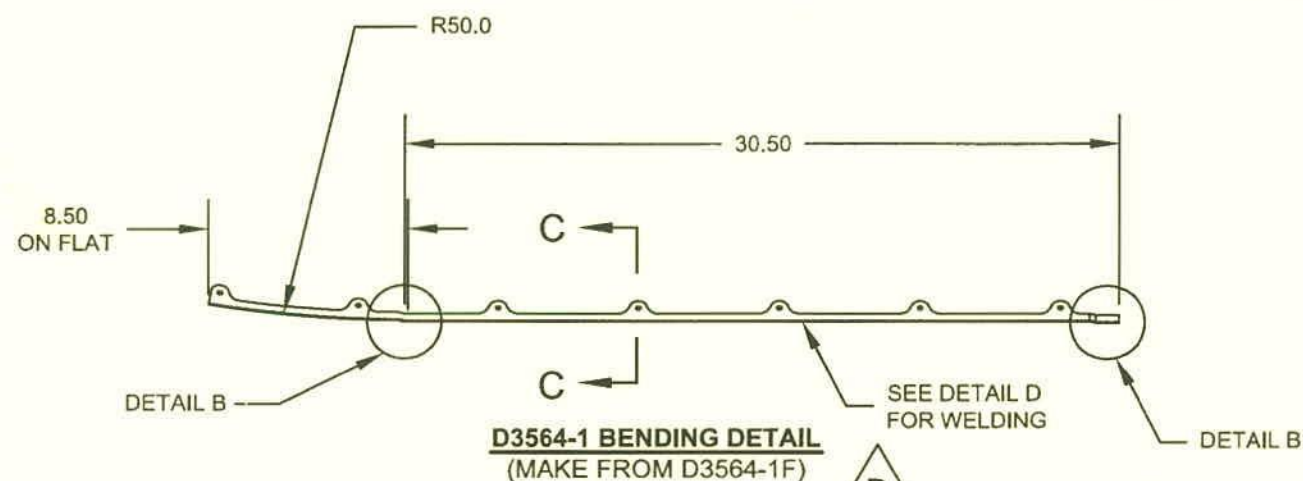
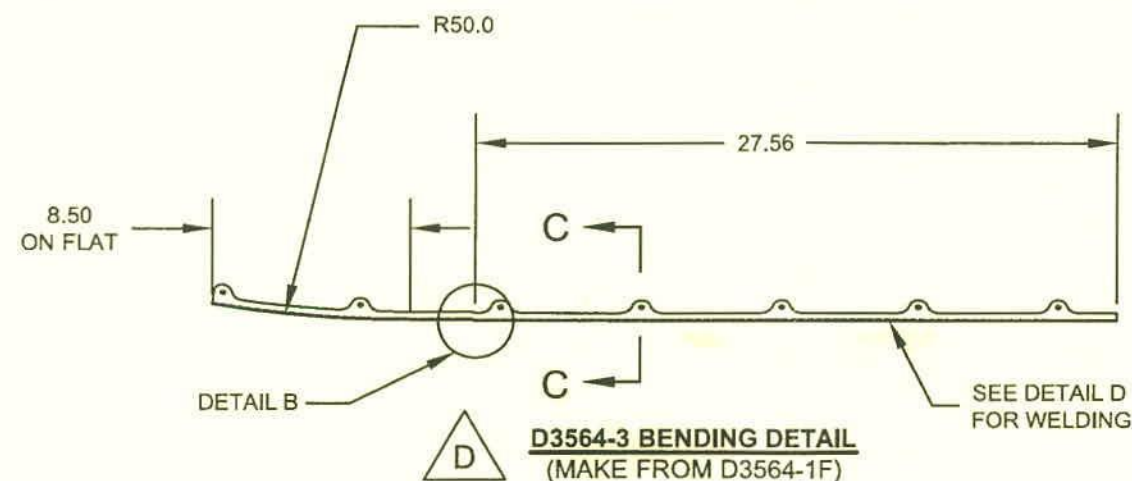
1



D3564-1F FLAT PATTERN

RELEASED

07.09.04

D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

NO. 5400
SHOP COPY
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WORK ORDER

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

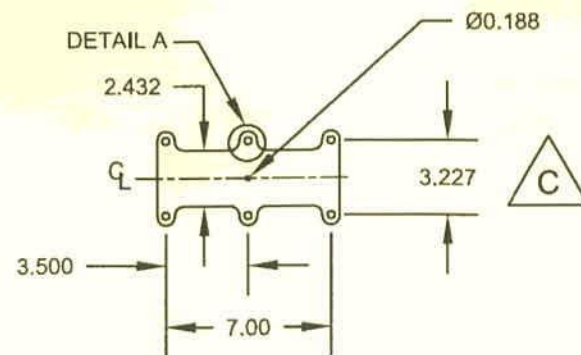
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT \bar{C}

WEIGHTS:

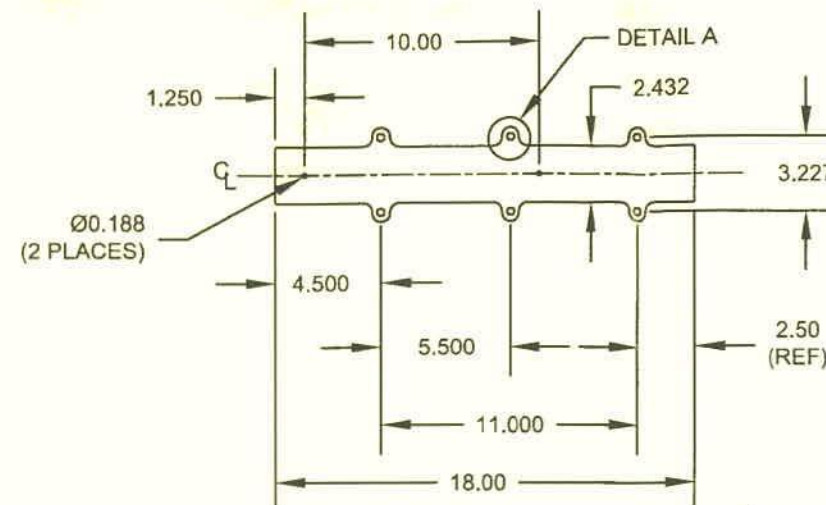
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE

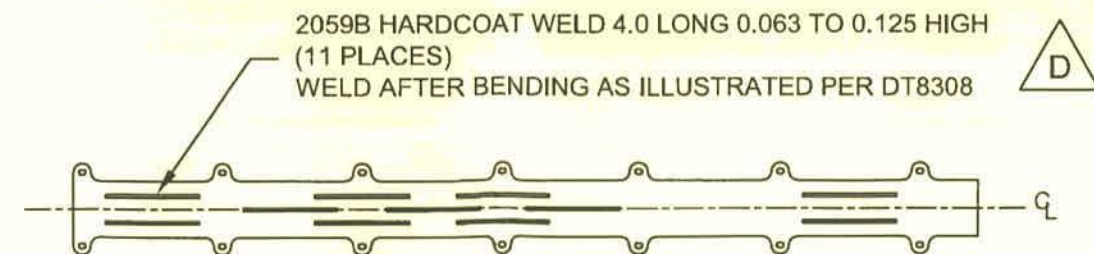
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 1 OF 3
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D3564-13F FLAT PATTERN

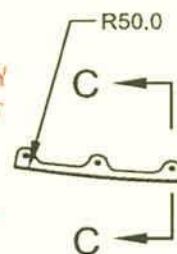


D3564-15F FLAT PATTERN

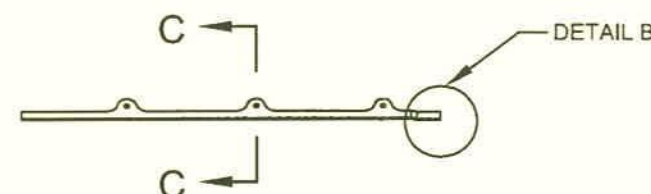


DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

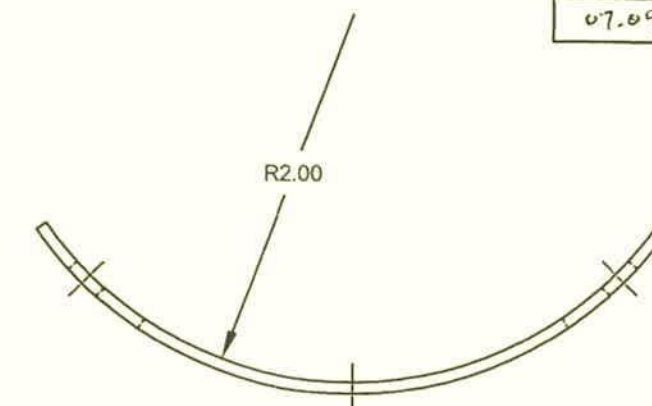
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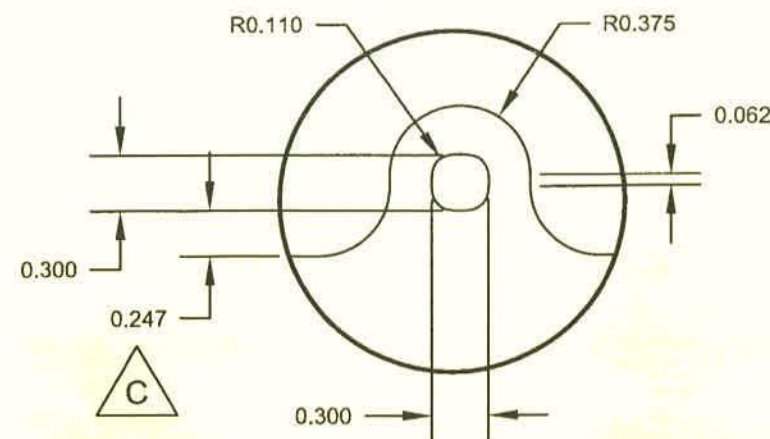
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



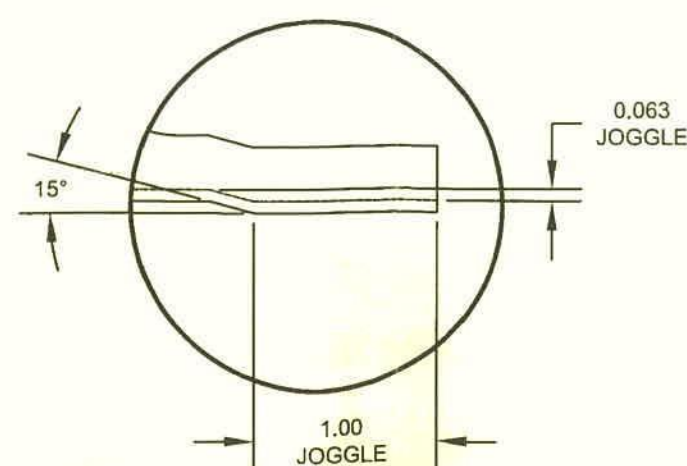
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO. D3564	REV. D
MFG. APPR.	PH	SHEET 3 OF 3	
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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